

Date: Wednesday, 2/15/2006 3:50:17 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
 Job Number : 25860
 Estimate Number : 10531
 P.O. Number : N/A Part Number : D2572
 This Issue : 2/15/2006 S.O. No. : N/A Drawing Number : D2572 REV DE
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : DE
 Previous Run : 25831 Material : N/A
 Due Date : 3/10/2006 Qty: 6 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06.02.16
 Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572

Ensure that grain is along 5.00" length

Batch No: B 24069

x 6

En 06/03/18

(6)

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No 325860 Double check by: J.L.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove shap edges.

15.G.

06/03/25

6

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

15.G.

06/03/25

6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:50:17 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G. 06/03/25 6

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 06-03-26

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a-m 06-03-27 (6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/03/28 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 4/3/29 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 479

PC 4/3/29 (6)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/03/30 (6)

Job Completion



W 06/03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25860
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.745	1.745	1.746	1.745		
C	3.495	3.505		3.498	3.495	3.495	3.496		
D	1.745	1.755		1.745	1.745	1.746	1.745		
E	7.990	8.010		8.004	8.003	8.003	8.001		
F	0.490	0.510		0.497	0.498	0.496	0.501		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.497	0.497	0.497		
J	1.174	1.184		1.177	1.178	1.178	1.178		
K	0.558	0.578		0.569	0.567	0.565	0.566		
L	1.174	1.184		1.177	1.178	1.178	1.178		
M	1.490	1.500		1.496	1.493	1.493	1.493		
N	2.495	2.505		2.496	2.495	2.497	2.495		
O	3.869	3.879		3.872	3.872	3.873	3.873		
P	0.115	0.135		0.129	0.127	0.127	0.127		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.252	0.252	0.251	0.255		
S	0.115	0.135		0.119	0.121	0.122	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.236	0.237	0.238		
W	0.115	0.135		0.122	0.125	0.124	0.123		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.360	0.365	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.623	0.622	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.249	0.245	0.248		
AE	1.375	1.395		1.385	1.387	1.387	1.386		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.265	0.260		
AH	0.240	0.260		0.246	0.248	0.247	0.251		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP
Date:	06/03/24

Audited by:	SH
Date:	06.03.26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 25860
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Inspection Dwg: D2572 Rev. E	Page 1 of 1

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C	3.495	3.505		3.497	3.498				
D	1.745	1.755		1.746	1.747				
E	7.990	8.010		8.005	8.005				
F	0.490	0.510		0.498	0.499				
G	0.257	0.262	DT8683	0.257	0.257				
H	0.375	0.380	DT8684	0.375	0.375				
I	0.490	0.510		0.501	0.500				
J	1.174	1.184		1.173	1.177				
K	0.558	0.578		0.566	0.567				
L	1.174	1.184		1.177	1.177				
M	1.490	1.500		1.494	1.494				
N	2.495	2.505		2.496	2.496				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		0.128	0.128				
Q	0.115	0.135		0.130	0.130				
R	0.240	0.260		0.253	0.252				
S	0.115	0.135		0.120	0.121				
T	0.178	0.198		0.188	0.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		0.235	0.234				
W	0.115	0.135		0.124	0.124				
X	0.307	0.312		0.310	0.310				
Y	0.760	0.765		0.760	0.760				
Z	0.352	0.372		0.365	0.365				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.623	0.625				
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AD	0.240	0.260		0.248	0.248				
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AF	0.115	0.135		0.130	0.130				
AG	0.240	0.280		0.260	0.260				
AH	0.240	0.260		0.251	0.250				
AI	2.000	2.020		N/A	N/A				
AJ	0.023	0.043		0.038	0.038				
Accept/Reject									

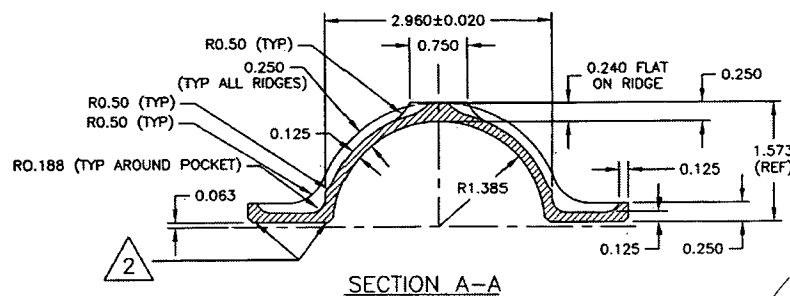
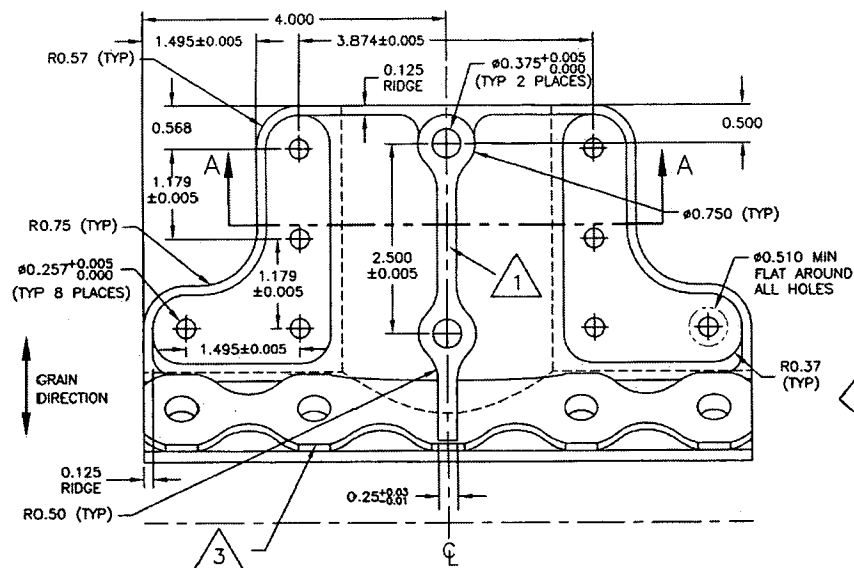
Measured by:	en
Date:	06/03/25

Audited by:	SD
Date:	06/03/26

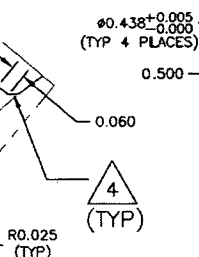
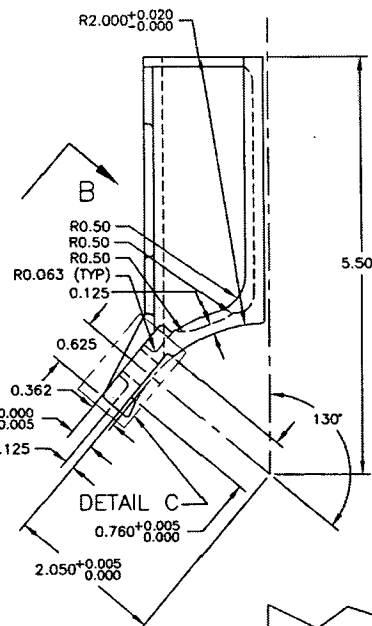
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D	05.05.05	Added dimension AI	KJ/RF	
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RELEASED

05.12.06



SECTION A-A

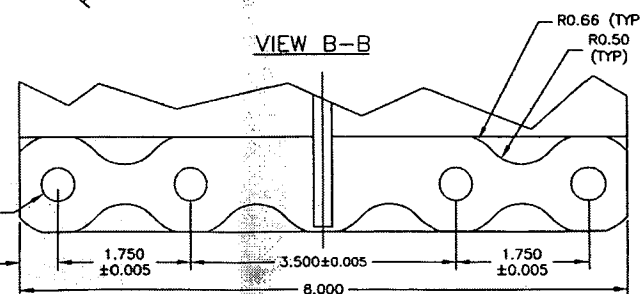
DETAIL C
SCALE 2:1

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
3 CHAMFER 0.063 x 45° ALL AROUND
4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	TITLE
		INNER FWD SADDLE

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